

Work Order ID 76386

\*76386\*

**U/R**

Page 1

November-11-11 12:41:49 PM

Item ID: D3391-021

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Fwd Tube Assembly

Stop \*NS2\*

Start Date: 11/11/2011 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 25/11/2011 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan: ✓

Date: 11-11-14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3391	Rev H U/R <u>OK 11.11.14</u>

100		0.00
*100*	Skidtubes	
Skidtubes	Memo	0.00
Skidtubes	Cut extrusion to 46.52 +0.010 -0.020	

DP 11-11-15

110		0.00
*110*	BENDING MACHINE - SKIDTUBES	
CNC Bend 1	Memo	0.00
CNC Delta 100 Bender	Bend as per Dwg D3391 Using Bend Prog 3391021	

DP 11-11-15

120		0.00
*120*	QC5- Inspect part completeness to step on W/O	
QC	Memo	0.00
Quality Control		

1 DP BE 11-11-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 76386

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Item ID: D3391-021 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Fwd Tube Assembly  
 Start Date: 11/11/2011 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 25/11/2011 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1  Memo 1-Machine as per Folio FA590 Rev. <u>AA</u> & Dwg D3391 Rev. <u>I</u> Identify as D3391-1 2-Deburr	0.00  0.00	<u>36/51</u>	<u>11/11/18</u>		<u>1</u>	<u>0</u>		
140 <b>*140*</b> QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00  0.00	<u>36/51</u>	<u>11/11/18</u>		<u>1</u>	<u>0</u>		
150 <b>*150*</b> Mill Conv Conventional Milling Machine	CONVENTIONAL MILLING MACHINE  Memo Drill X1 Aft cap as per Dwg D3391 .1875" dia	0.00  0.00	<u>36/51</u>	<u>11/11/18</u>		<u>1</u>	<u>0</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*N900040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

**Start Date:** 11/11/2011    **Start Qty:** 1.00    **\*1\***

**Cust Item ID:**

**Required Date:** 25/11/2011      **Req'd Qty:** 1.00      **\*1\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC2- Inspect parts off machine FAI/FAIB

0.00

**\*160\***

0.00

QC

## Memo

## Quality Control

170 QC8- Inspect parts - second check

0.00

**\*170\***

0.00

QC

## Memo

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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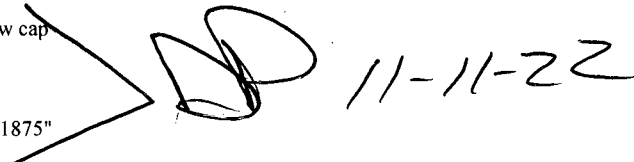
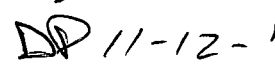
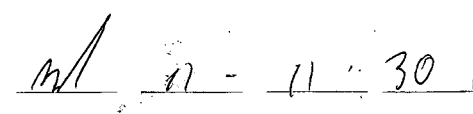
**\*76386\***

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Item ID: D3391-021 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Fwd Tube Assembly  
 Start Date: 11/11/2011 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 25/11/2011 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Skidtubes	0.00							
<b>*180*</b>									
Skidtubes	Memo	0.00							
Skidtubes	1-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size) (ONLY DRILL HOLES MARKED "A") 2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step 3-Open tow cap holes to .208" as per Dwg D3391 4-Open Tow Ring hole to .640" as per Dwg D3391 5- open float bag holes 0.328" and counter sink as per dwg D3391 6-Deburr & Scribe Batch number Inside aft end. 7-Transfer drill D3391-021 with D3391-023								 
190	QC5- Inspect part completeness to step on W/O	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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 Item Name: Fwd Tube Assembly  
 Start Date: 11/11/2011 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 25/11/2011 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*200*</b>									
HandFinish	Memo	0.00							(1) 11-12-01
Hand Finishing									
210	QC3- Inspect Part Finish	0.00							
<b>*210*</b>									
QC	Memo	0.00							DP 11-12-1
Quality Control									
220	Skidtubes	0.00							
<b>*220*</b>									
Skidtubes	Memo	0.00							DL 11/02/02
Skidtubes	1-instal spacers as per dwg D3391 A/R Magnabond 6398 batch: 112870 exp. date: 02/12 cure time 12hrs. as per QSI015 2- grind crossbolt flush 3-back drill crossbolt if necessary								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Item ID: D3391-021 Accept **\*N900040100\*** Setup Start **\*NS1\***  
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 Item Name: Fwd Tube Assembly  
 Start Date: 11/11/2011 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 25/11/2011 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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230	QC5- Inspect part completeness to step on W/O	0.00							
<b>*230*</b>									
QC	Memo	0.00		Swizlos					
Quality Control									

235	Pressure Wash per QSI005 4.3	0.00							
<b>*235*</b>									
HandFinish	Memo	0.00							
Hand Finishing	AND REALODINE AS PER PAR09-043								

240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*240*</b>									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 10:20								
	OVEN TEMPERATURE: 3200F								
	FINISH TIME: 10:50								

W118439

1XØ M-11/12/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

November-11-11 12:41:49 PM

**Item ID:** D3391-021  
**Revision ID:**  
**Item Name:** Fwd Tube Assembly

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop **\*NS2\***

**Start Date:** 11/11/2011    **Start Qty:** 1.00    **\*1\***

**Cust Item ID:**

**Required Date:** 25/11/2011      **Req'd Qty:** 1.00      **\* 1 \***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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**\*76386\***

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Item ID: D3391-021 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Fwd Tube Assembly  
Start Date: 11/11/2011 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 25/11/2011 Req'd Qty: 1.00 **\*1\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	Identify as per dwg & Stock Location: <u>W10</u>	0.00							
<b>*260*</b>									
Packaging	Memo	0.00							
Packaging									
280	QC21- Final Inspection - Work Order Release	0.00							
<b>*280*</b>									
QC	Memo	0.00							
Quality Control									

0412-742-043/1376400

11/12/09

CME  
11-12-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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# Picklist Print

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Page 1

Work Order ID: 76386

\*76386\*

Parent Item: D3391-021

\*D3391-021\*

Parent Item Name: Fwd Tube Assembly

Start Date: 11/11/2011

Required Date: 25/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A05.09.13New issue KJ/JLM  
 IPP B06.02.10Dwg rev.D ecn 773 EC  
 IPP C06.05.02Added inspections EC  
 IPP D 07.03.13 rev F dwg EC  
 IPP E 07.11.07 revG dwg ecn1053P EC verified by: DD  
 IPP Rev:f ECN 1056 07-11-12 DD verified by: EC  
 IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC  
 IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC  
 IPP Rev J 09.02.02 added hardware EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6013-047		Manufactured	No			100	Each	8.0000	1	1			
*D6013-047*													
Skidtube Material													
**													
11-11-15													

Location	Loc Qty	Loc Code
LG	8	
26547	8	
D3670-4-200		
Manufactured	No	
220	Each	104.0000
**		
Wh. 11/12/02		

Location	Loc Qty	Loc Code
LG	12	
71850	12	
LG001	92	
72851	92	
D3401-041		
Manufactured	No	
255	Each	1.0000
**		
B71878(x1) 11/12/08		

Location	Loc Qty	Loc Code
FP007	1	
71352	1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 76386

**\*76386\***

Parent Item: D3391-021

**\*D3391-021\***

Parent Item Name: Fwd Tube Assembly

Start Date: 11/11/2011

Required Date: 25/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-13

Manufactured No

255

Each

17.0000

1

1

**\*D3564-13\***

Wearshoe

\*\*

1376220 (x1) H 11/12/08

D4045-051

UP 11.12.08

Location

Loc Qty

Loc Code

FP001

16

73323

16

FP017

1

71594

1

D3566-13

Manufactured No

255

Each

30.0000

1

1

**\*D3566-13\***

Gasket

\*\*

N/A

N/A 11.12.08

Location

Loc Qty

Loc Code

FP

29

73322

29

FP014

1

68341

1

AN960C10L

NAS1149C0332  
R

Purchased

No

255

Each

0.0000

10

10

**\*AN960C10I \***

washer

\*\*

M119736 (x10) H 11/12/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D3391-021

\*D3391-021\*

Parent Item Name: Fwd Tube Assembly

Start Date: 11/11/2011

Required Date: 25/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No

255 Each 2,163.000 10 10

\*AN3C4A\*

BOLT

\*\*

11/12/08

## Location

## Loc Qty

## Loc Code

ST350

2163

117313

2

117688

5

117872

22

118112

16

118451

2

118706

142

118838

974

119328

1000

x10

D3672-1 Manufactured No

255 Each 688.0000 4 4

\*D3672-1\*

Phenolic Washer

\*\*

11/12/08

## Location

## Loc Qty

## Loc Code

FP-A

424

52505

0

66821

424

x4

ST074

264

72229

264

AELS-1032-130 Purchased No

255 Each 0.0000 2 2

\*AFI S-1032-130\*

INSERT

AL57-1032-130

1119530

\*\*

(x2) 11/12/08

AELS-1032-225

Purchased No

255 Each 0.0000 10 10

\*AFI S-1032-225\*

INSERT

\*\*

1118966 (x10) 11/12/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

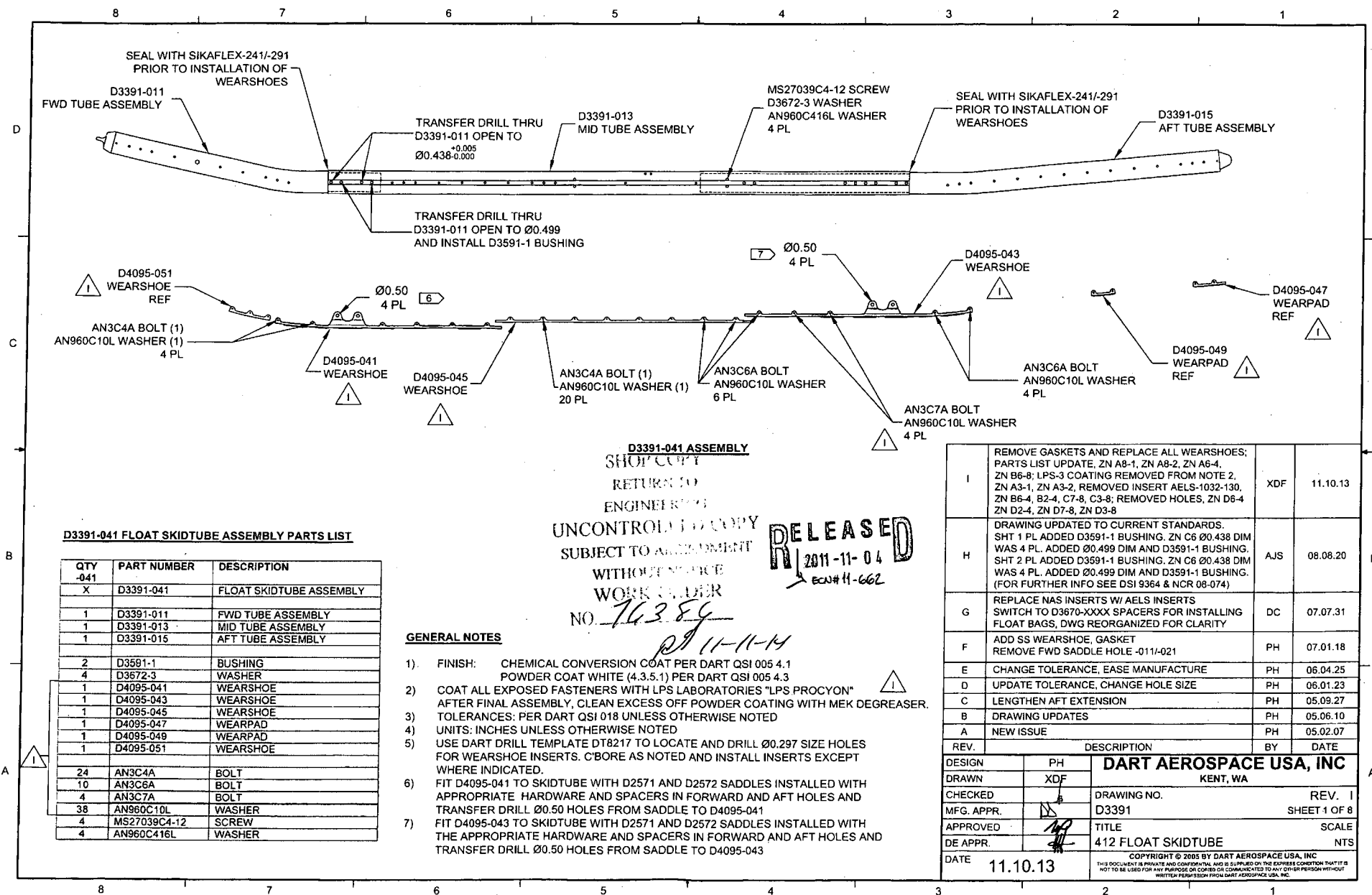
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

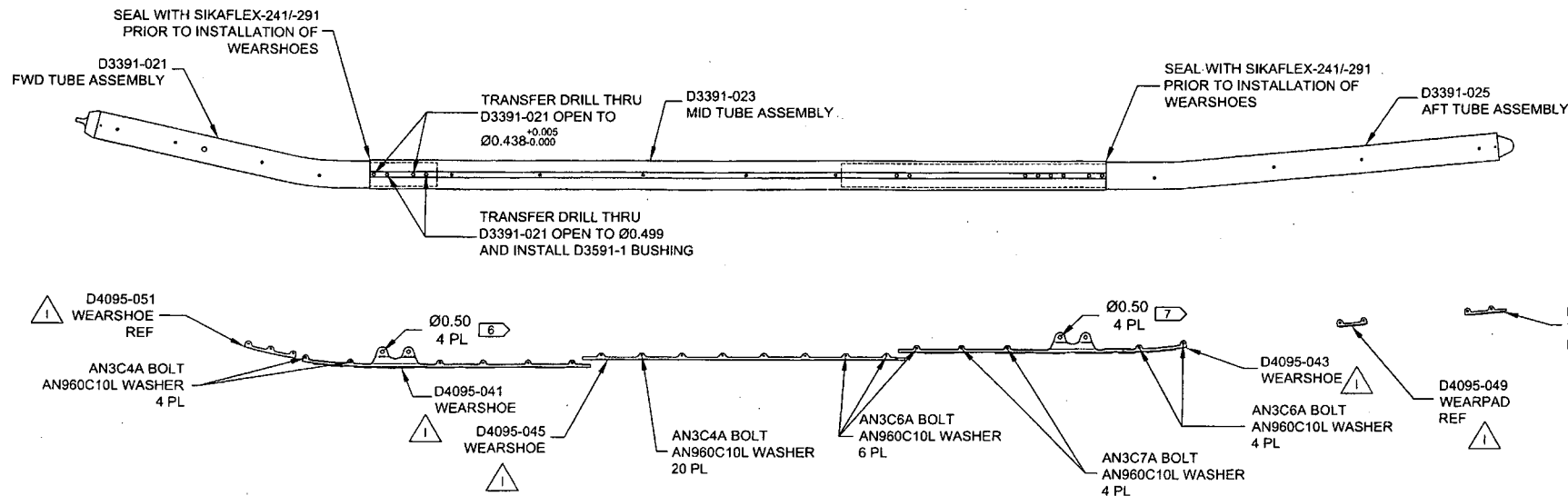
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#### D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -043	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

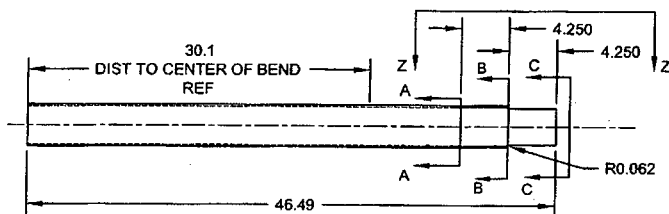
#### GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
- 3) AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 7) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 8) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

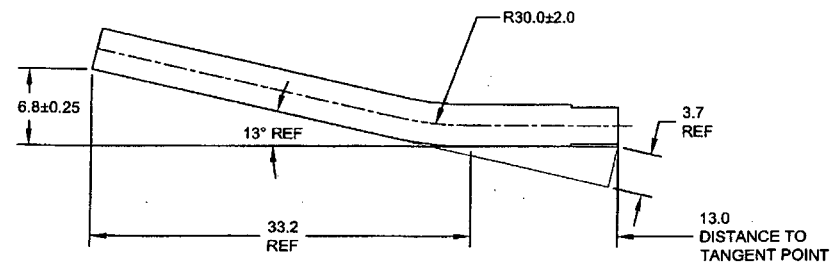
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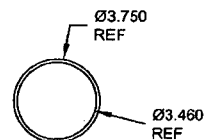
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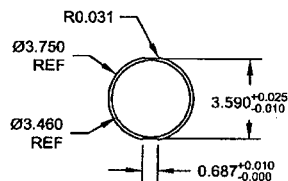
**D3391-1 CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



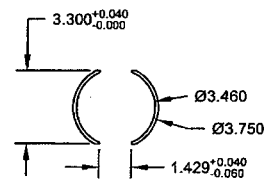
**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)



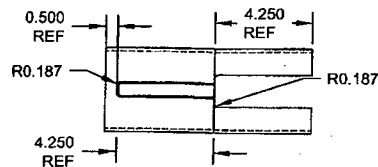
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SCALE 2X



**SECTION B-B**  
SCALE 2X



**SECTION C-C**  
SCALE 2X

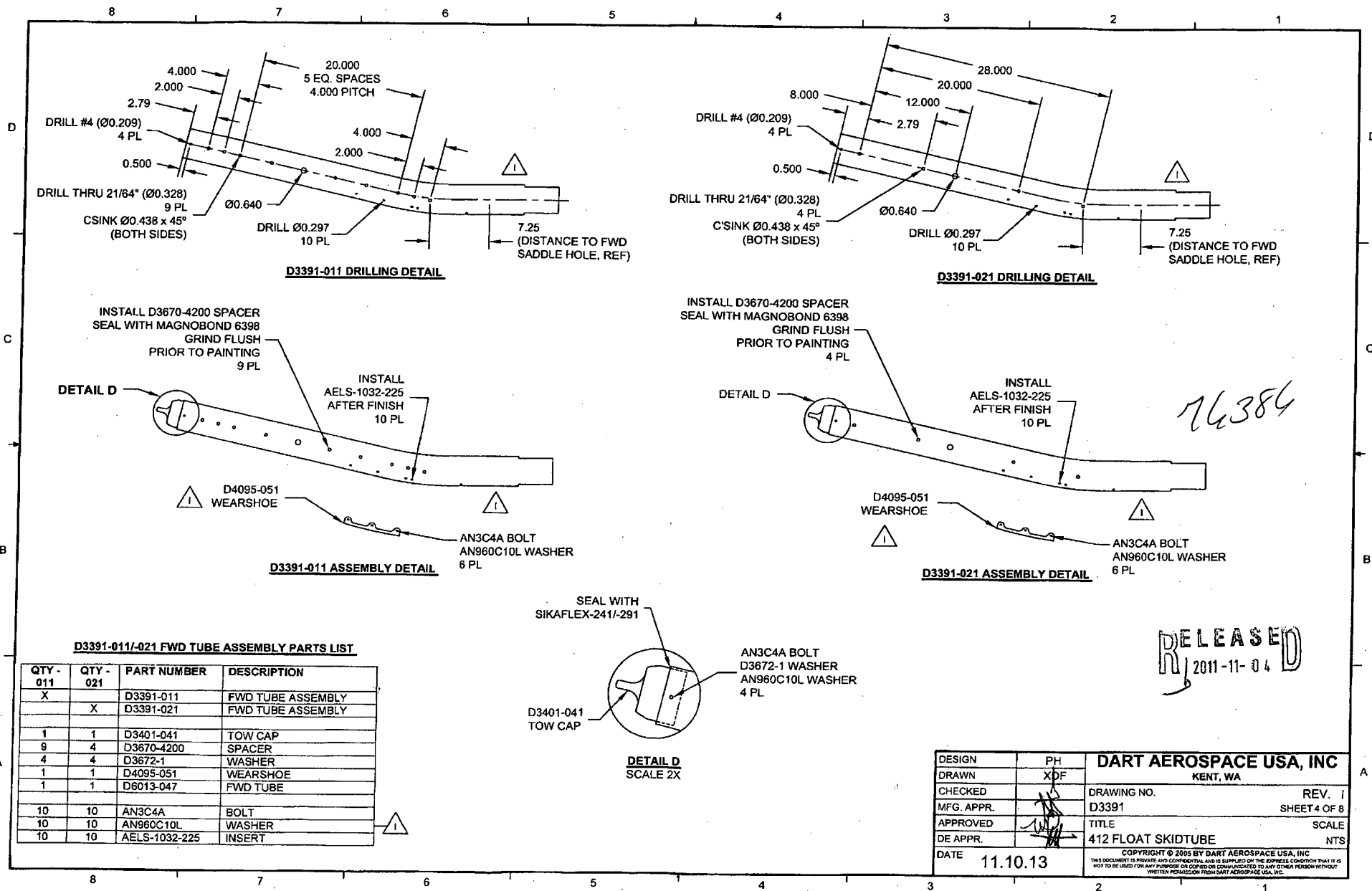


**VIEW Z-Z**  
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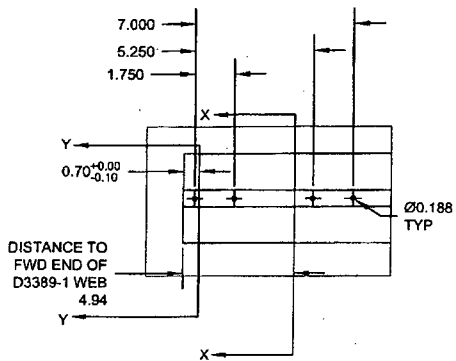
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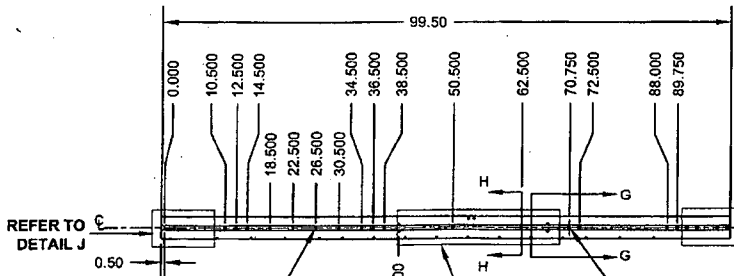
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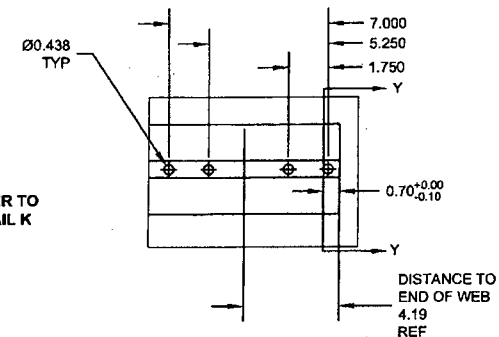
8 7 6 5 4 3 2 1



DETAIL J  
SCALE 4X



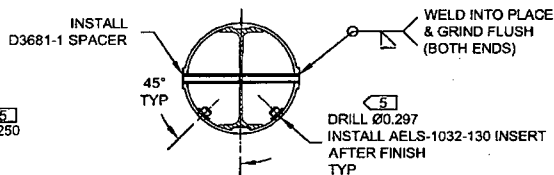
D3391-013 ASSEMBLY DETAIL



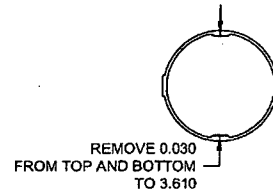
DETAIL K  
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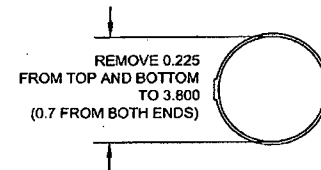
SECTION G-G  
SCALE 5X



SECTION H-H  
SCALE 5X



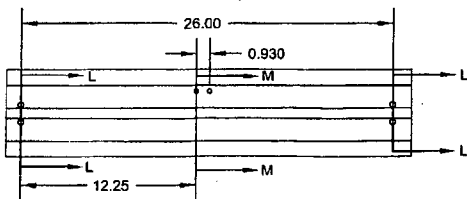
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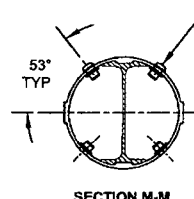
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D3391-013 MID TUBE ASSEMBLY PARTS LIST

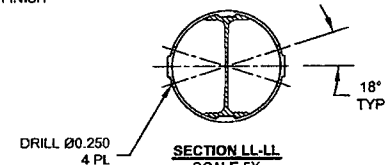
QTY	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



DETAIL E  
SCALE NONE

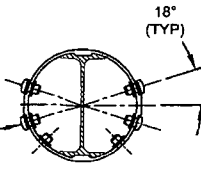


SECTION M-M  
SCALE 5X



SECTION LL-LL  
SCALE 5X

DRILL 0.391  
INSTALL ALS4-428-165 INSERT  
MS27039C4-08 SCREW  
D3672-3 WASHER  
AN960C416L WASHER  
AFTER FINISH  
4 PL



SECTION L-L  
SCALE 5X

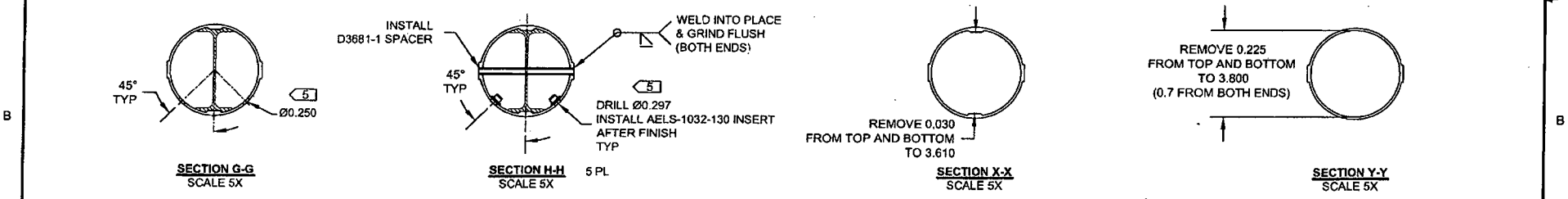
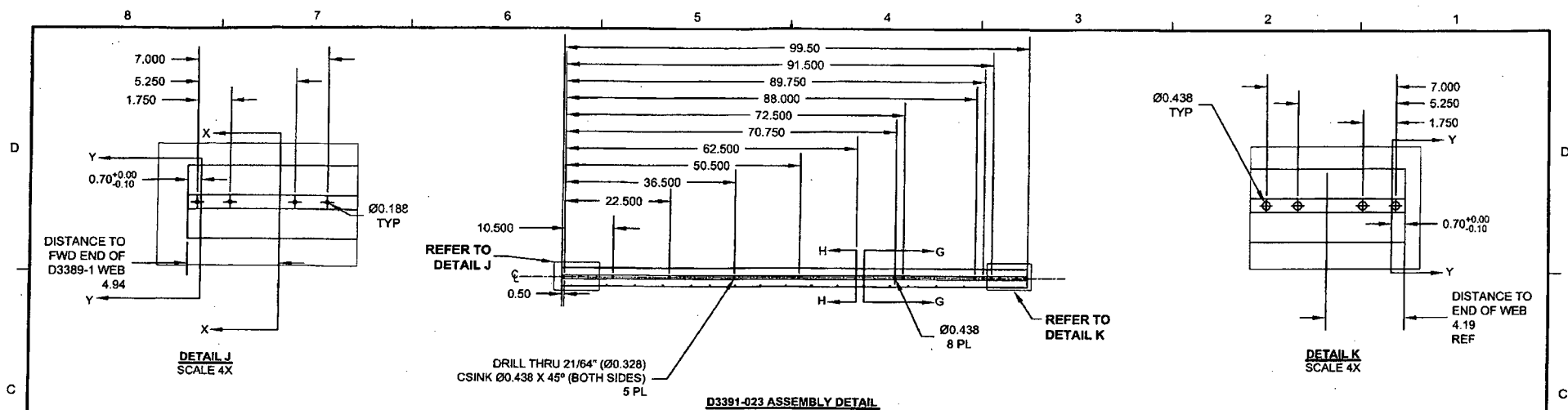
D3391-013 MID TUBE ASSEMBLY

- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- WELDING: PER DART QSI 004

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**D3391-023 MID TUBE ASSEMBLY PARTS LIST**

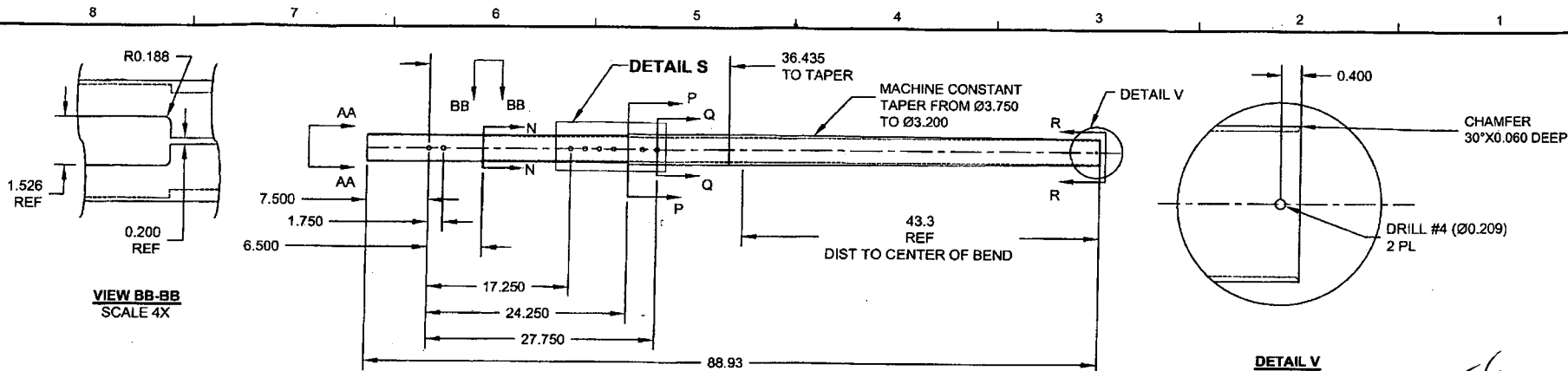
QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

- D3391-023 MID TUBE ASSEMBLY**
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
  - 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
  - 3) WELDING: PER DART QSI 004

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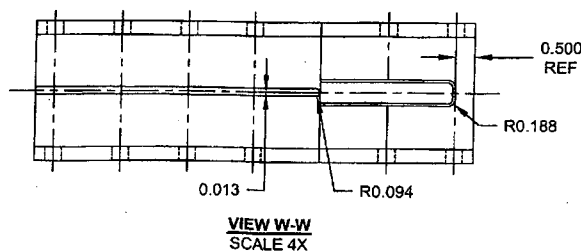
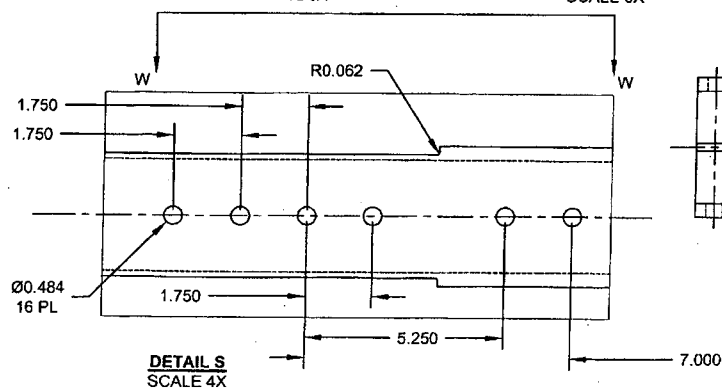
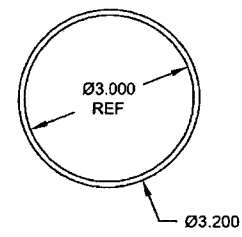
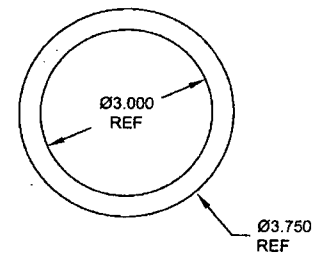
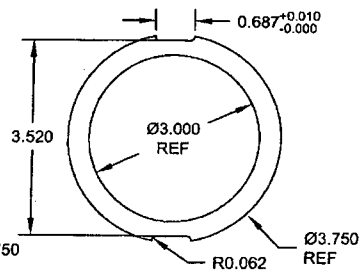
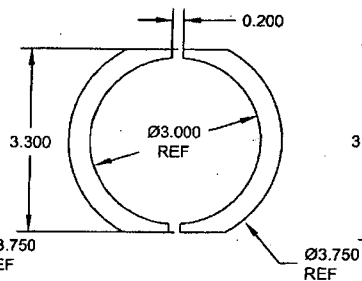
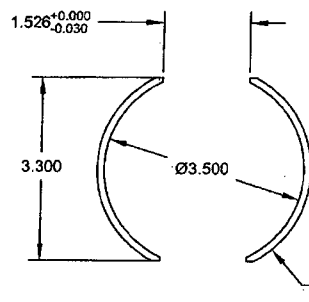
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**D3391-3 AFT DRILLING AND CUTTING DETAIL**  
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)

76386  
DETAIL V  
SCALE 6X



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